

Date: Thursday, 19/02/2009 10:45:12 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STOP		
Job Number	: 45886A						
Estimate Number	: 10731						
P.O. Number	:			Part Number	: D23243		
This Issue	: 19/02/2009 S.O. No. :			Drawing Number	: D2324 REV. C		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: 19/02/2009 Type : SMALL /MED FAB			Drawing Revision	: C		
Previous Run	: 39583A			Material	:		
Written By	:			Due Date	: 03/03/2009		
Checked & Approved By	: <u>JL 09/02/19</u>			Qty:	10 Um: Each		
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00750	6061-T6 Bar .750 x .750	(10)
		Comment: Qty.: 0.5565 f(s)/Unit Total : 5.5650 f(s) 6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8) (M6061T6B0.750x00.750) Batch: <u>M108877</u>	JL 09/02/23
2.0	BAND SAW	BAND SAW	(10)
		Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar	JL 09/02/23
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	(10)
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges Identify as D2324-3	HA 09/02/24
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	(10)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	HA 09/02/24
5.0	QC8	SECOND CHECK	(10)
		Comment: SECOND CHECK	<u>DT 09/02/25</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/02/2009 10:45:12 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 45886A

Part Number: D23243

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(D)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 09-02-26

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

09-02-26

670

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

EP09/02/26

(10)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/26 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 09/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	N5886A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>H.A</u>	Audited by: <u>DJP</u>	Prototype Approval:	N/A
Date: 09/02/24	Date: 09/02/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue P/O D2324-1	KJ/JLM	<i>[Signature]</i>
B	06.03.08	Dwg Rev changed	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

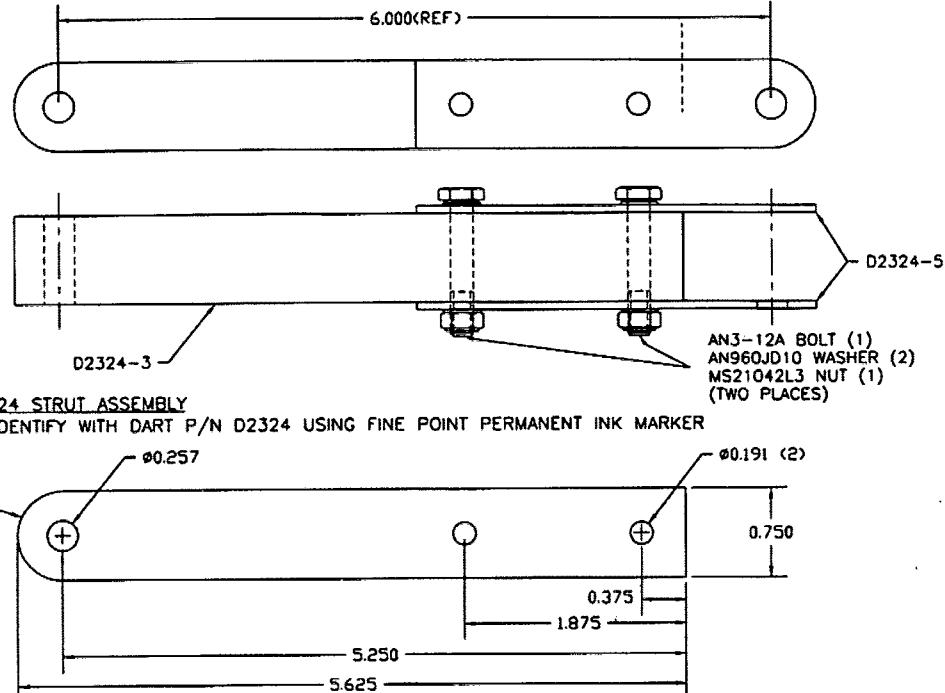
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

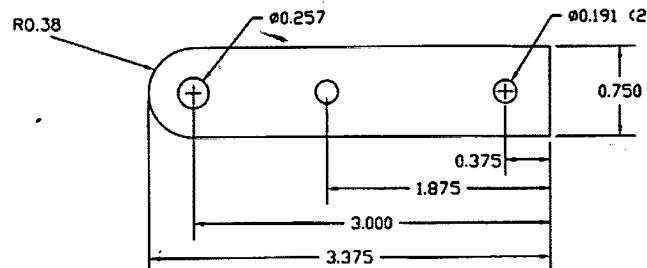
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2324
DATE 04.12.14	TITLE STRUT	REV. C SHEET 1 OF 1
A	94.11.08	SCALE NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

RELEASED04.12.16 *[initials]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY**RETURN TO****ENGINEERING****UNCONTROLLED COPY****SUBJECT TO AMENDMENT****WITHOUT NOTICE****WORK ORDER****NO. 15880A**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries